

Work Order ID 61871

Wednesday, September 08, 2010 1:34:18 PM



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Item ID: D4079-1

Accept



Setup Start



Revision ID:

Item Name: Clamp Half, Attachment

Stop



Start Date: 9/8/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: *M*Date: *10-9-08*

Tooling:

Date:

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D4079	B

100



Bandsaw

Jeaspa Bandsaw

Memo

Cut blank 2.750" long

0.00

*On 10/09/26**12 8*

110



HAAS I

HAAS CNC vertical machine #1

Memo

Mill as per Dwg and Folio FA931

Folio rev: *A*Dwg Rev: *B*

0.00

*M.A 10/09/26**12 0*

Deburr

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Item ID: D4079-1**Revision ID:****Item Name:** Clamp Half, Attachment**Start Date:** 9/8/2010 **Start Qty:** 12.00**Required Date:** 9/13/2010 **Req'd Qty:** 12.00**Reference:****Approvals:****Process Plan:****Date:****Tooling:****Date:****Run****Start****QC:****Date:****SPC (Y/N):****Date:****Stop****Sequence ID/
Work Center ID**

120



QC

Quality Control

**Operation
Description**

QC2- Inspect parts off machine FAI/FAIB

**Set Up/
Run Hours**

0.00

Tool ID**Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

B.A 10/09/26

12 0

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

ML 10/09/27

12 0

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

X 10-9-28.

12 0

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Item ID: D4079-1

Revision ID:

Item Name: Clamp Half, Attachment

Start Date: 9/8/2010 Start Qty: 12.00

Required Date: 9/13/2010 Req'd Qty: 12.00

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop		

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 M112588 START 10:35. Memo 00PT. 3200 FINISH 11:05.	0.00	BL10-9-29.						

160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00	=> M1 10/09/29	12	0	
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170 Packaging Packaging	Identify as per dwg & Stock Location: <u>123</u> Memo	0.00				
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10/9/28 sf (123)

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Item ID: D4079-1

Accept



Setup Start



Revision ID:

Item Name: Clamp Half, Attachment

Stop



Start Date: 9/8/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

180

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
StampQC
Quality Control

Memo

0.00

10/09/30 JF

MF
10-9-29

Picklist Print

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Work Order ID: 61871



Parent Item: D4079-1



Parent Item Name: Clamp Half, Attachment

Start Date: 9/8/2010

Required Date: 9/13/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV: A NEW ISSUE 10*-05-10 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.00 0		Purchased		No		100	f	41.5135	0.23	2.905263			

6061-T6 Bar 2.00 x 2.00



Location	Loc Qty	Loc Code
MAT09	41.5135	
113006	20	
113123	12.5135	
13085	9	

2.905 9/8/10/09/26

DART AEROSPACE LTD		Work Order: 61871
Description: CLAMP HALF, ATTACHMENT		Part Number: D4079-1
Inspection Dwg: D4079 Rev: B		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.502	+/- .010	2.505	✓		Vern	GA-01
Ø 0.203	+ .005 / -.001	Ø 0.205	✓		"	"
0.75	+/- .030	0.747	✓		"	"
0.375	+/- .010	0.375	✓		"	"
0.310	+/- .010	0.309	✓		"	"
1.882	+/- .010	1.882	✓		"	"
0.78	+/- .030	0.781	✓		"	"
R 0.13	+/- .030	R 0.125	✓		Rad gage	ref
1.440	+/- .010	1.438	✓		Vern	GA-01
R 0.38	+ .010 / -0.000	R 0.380	✓		Rad gage	ref
R 0.050	+/- .010	R 0.050	✓		"	"
R 0.73	+/- .030	R 0.730	✓		"	"
Ø 0.257	+ .006 / -.001	Ø 0.258	✓		Vern	GA-01
R 0.25	+/- .030	R 0.250	✓		Rad GAGE	ref
0.390	+/- .010	0.390	✓		Vern	GA-01
0.850	+/- .010	0.852	✓		"	"
0.025 X 45°	+/- .010	0.025 X 45°	✓		"	"
0.100	+/- .010	0.099	✓		"	"
R 0.05	+/- .030	R 0.063	✓		Rad Gage	ref.
1.240	+/- .010	1.239	✓		Vern	GA-01
1.65	+/- .030	1.654	✓		Height gage	31006
0.60	+/- .030	0.599	✓		"	"
0.23	+/- .030	0.228	✓		Vern	GA-01

Measured by:	J. A	Audited by:	Onf	Preliminary Approval:	AA
Date:	10/09/26	Date:	10/09/27	Date:	11/14

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

DART AEROSPACE LTD	Work Order:	61871
Description: CLAMP HALF, ATTACHMENT	Part Number:	D4079-1
Inspection Dwg: D4079 Rev: B		Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	B. A	Audited by:	✓	Preliminary Approval:	N/A
Date:	10/09/26	Date:	10/09/26	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

